

इंटरनेट

मानक

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“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 11831 (1986): Jig foot bolts [PGD 2: Machine Tool Elements and Holding Devices]



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“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

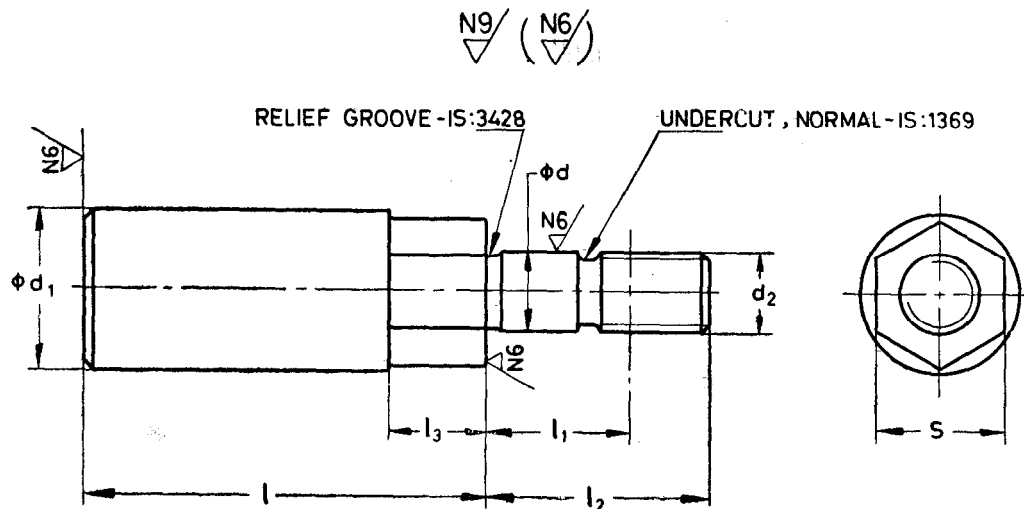
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Indian Standard

SPECIFICATION FOR JIG FOOT BOLTS

1. Scope — Covers dimensions and other requirements for jig foot bolts used with jig foot nuts according to IS : 11843-1986 'Specification for jig foot nuts'.

2. Dimensions

All dimensions in millimetres.

d h6	d_1	d_2	l	l h11				l_2	Jig Plate Thickness, l_1		l_3	S h14
									Min	Max		
10	20	M10	50	75	100	—	—	28	12	18	12	16
12	25	M12	50	75	100	125	150	35	19	23	12	18

Note 1 — The length of the plug from the shoulder including both the under cut shall be less than the thickness of the jig plate.

Note 2 — Dimensional deviations for untoleranced dimensions: Medium class according to IS : 2102 (Part 1)-1980 'General tolerances for dimensions and form and positions: Part 1 General tolerances for linear and angular dimensions (second revision)'.

3. Threads — Shall be 6 g class as per IS : 4218 'ISO metric screw threads'.

4. Material — Steel having tensile strength of 370 MPa, *Min.*

4.1 The chamfered face of diameter d_1 , if agreed to between the manufacturer and the user, shall be hardened to 550 HV, *Min.*

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IS : 11831 - 1986

5. Designation — A jig foot bolt having $d_1 = 20$ mm and $l = 100$ mm shall be designated as:
Jig Foot Bolt 20 × 100 IS : 11831

6. Finish — The jig foot bolts shall be free from cracks, burrs, pits and other defects.

7. Preservation and Packing

7.1 A suitable anti-corrosive surface treatment shall be given to jig foot bolts.

7.2 Jig foot bolts shall be packed in suitable cartons so as to prevent damage during transit.

8. Marking — The cartons containing the jig foot bolts shall be marked with designation and the manufacturer's name or trade-mark.

8.1. Certification Marking — Details available with the Bureau of Indian Standards.

EXPLANATORY NOTE

In preparation of this standard, assistance has been derived from BS : 5078 - 1974 'Specification for jig and fixture components : Table 41 jig foot bolts, steel' issued by the British Standards Institution.